

Date: Tuesday, 13/01/2009 4:07:38 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT GUIDE PLATE
<b>Job Number</b> : 44740	
<b>Estimate Number</b> : 13356	
<b>P.O. Number</b> :	<b>Part Number</b> : D358919
<b>This Issue</b> : 13/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3589 REV B PRELIM
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B PRELIM
<b>Previous Run</b> : 05015	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/01/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>mf 09-1-13</u>	
<b>Comment</b> : Est Rev:A 08-05-30 new issue DD verified by:ec	

## Additional Product

PRELIMINARY ISSUE

Job Number:



209/01/15 per ECN#09.502P

<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.0149 sf(s)/Unit Total: 0.0149 sf(s)  
 304/316 .063 Sheet  
 batch: 109057 HB 9-1-15

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3589  
 Dwg Rev: pde  
 Prog Rev: Lim

HB 9-1-15

①

2-Deburr if necessary

HB 9-1-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-1-15

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

ENGINEERING  
APPROVALHB 9-1-15 ①

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** Form as per dwg D3589

HB 9-1-15 ①

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	44740
<b>Description:</b> AFT GUIDE PLATE	<b>Part Number:</b>	D3589-19
<b>Inspection Dwg:</b> D3589-19, <b>Rev:</b> PRELIM		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

Measured by:	HB
Date:	9-1-15

<b>Audited by:</b>	
<b>Date:</b>	09.01.15

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

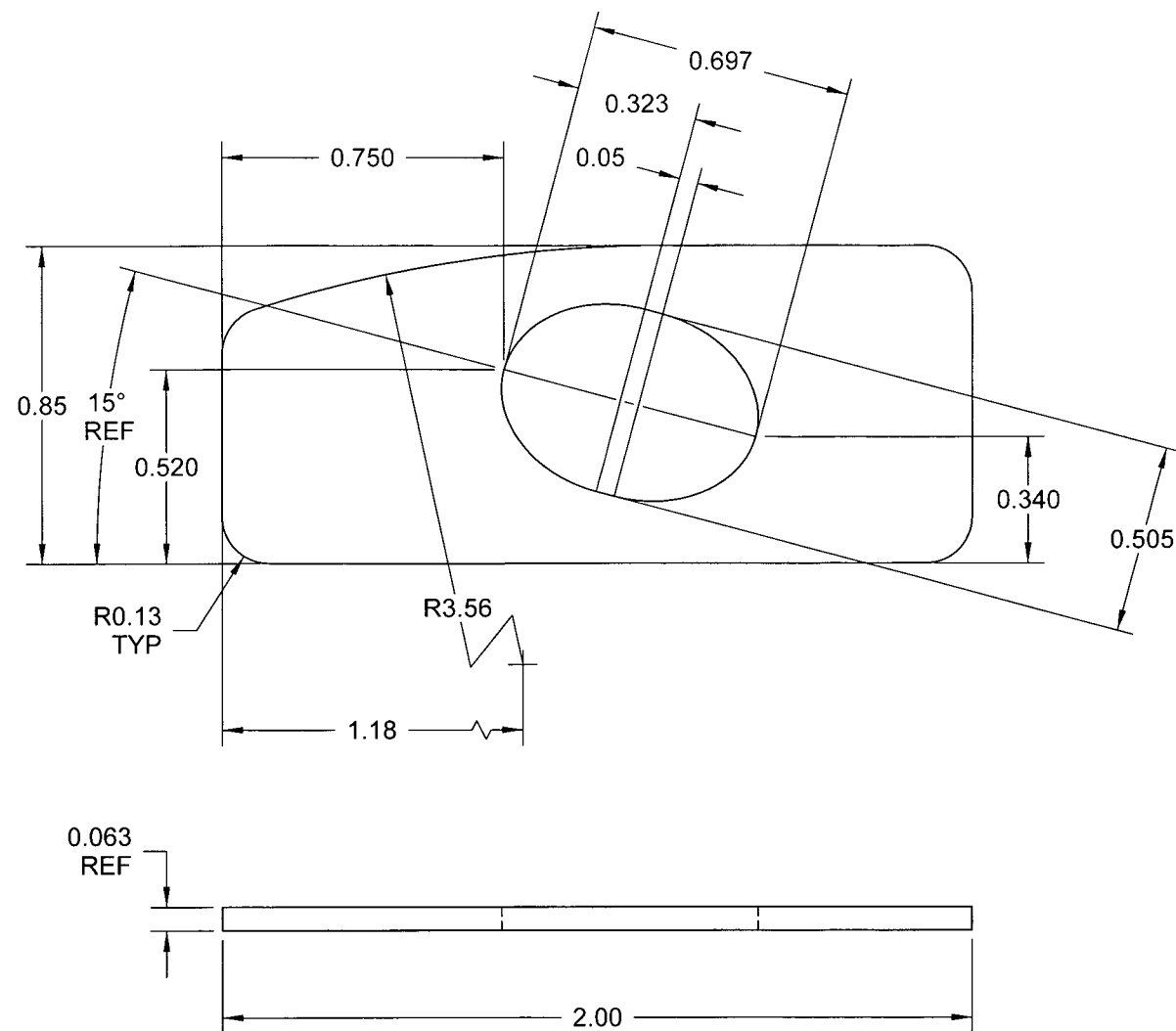
8 7 6 5 4 3 2 1

D

C

B

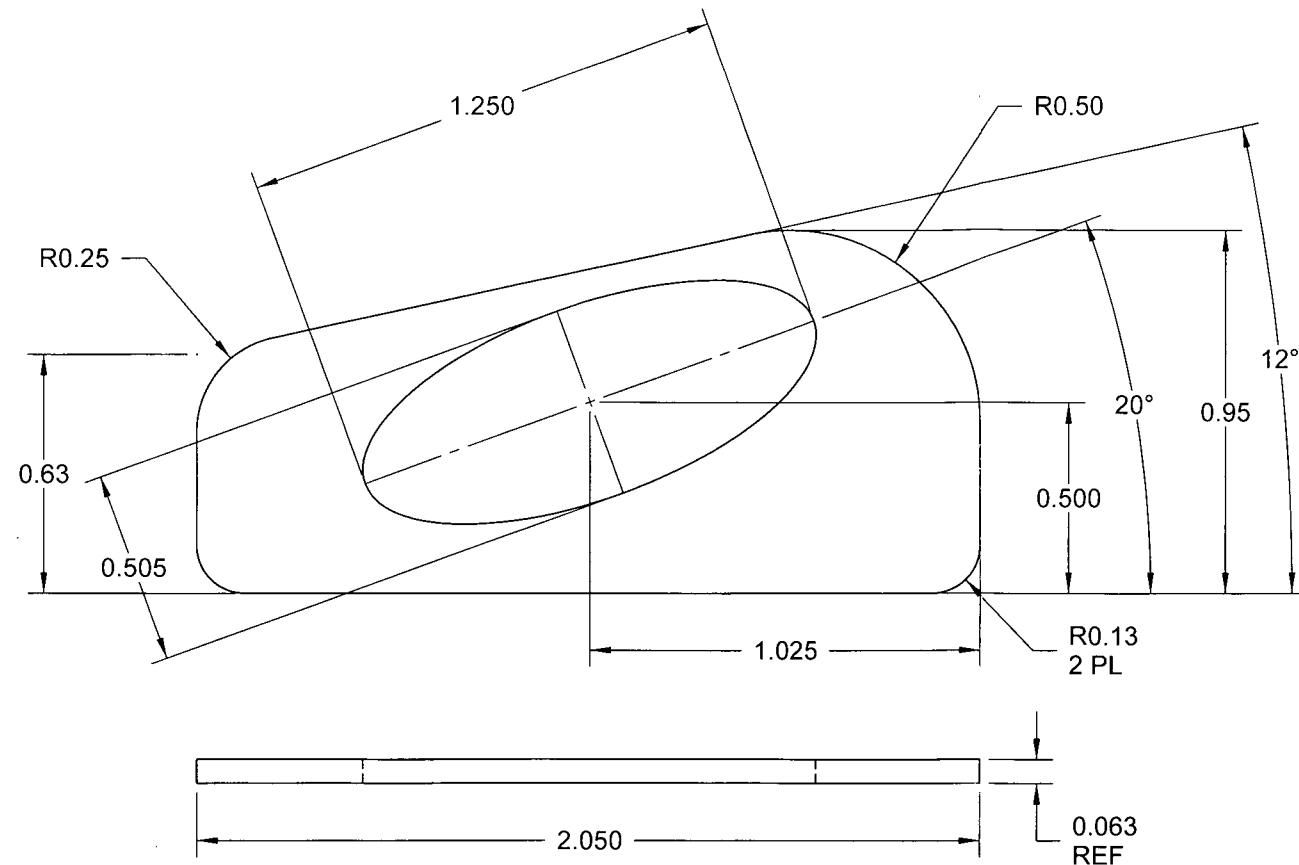
A



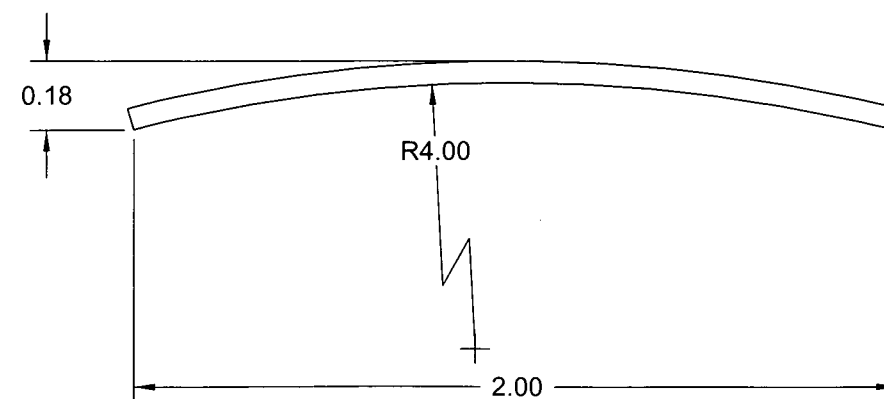
**D3589-17 FORWARD GUIDE PLATE**

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

44740  
**PRELIMINARY ISSUE**  
209.01.17 PDL CEN#  
04.5022

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

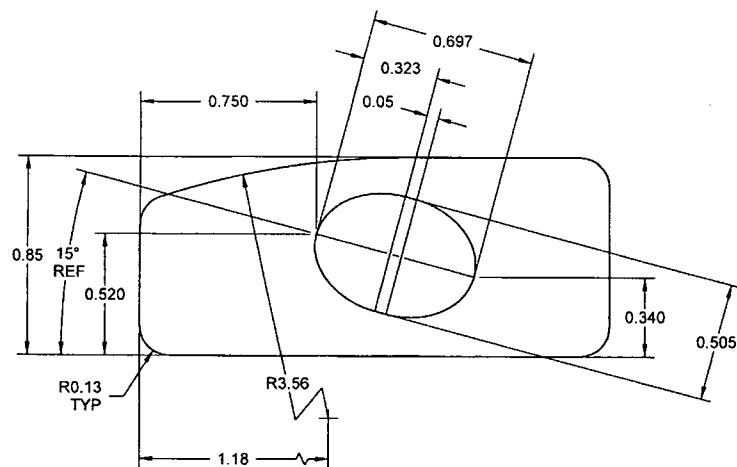
8 7 6 5 4 3 2 1

D

C

B

A



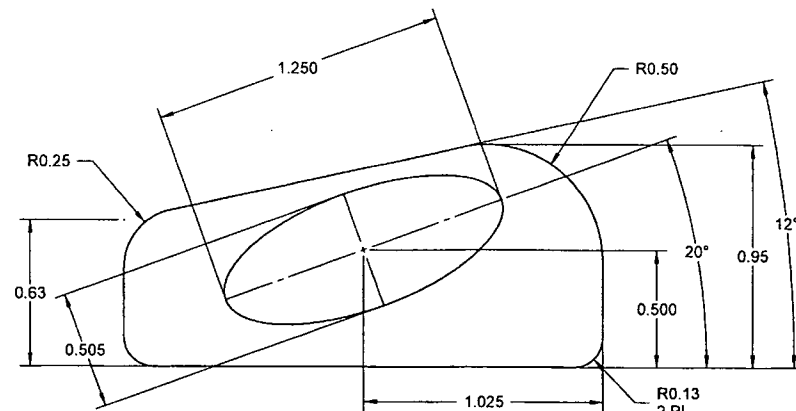
**D3589-17 FORWARD GUIDE PLATE**

44740

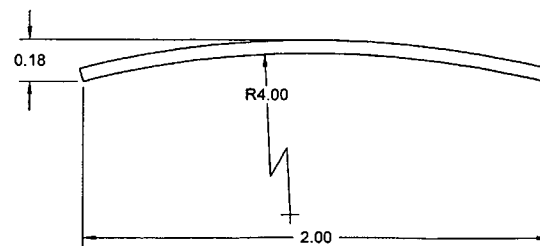
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8 7 6 5 4 3 2 1



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

**RELEASED**  
09/26/05

DESIGN	<i>AK</i>	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AK</i>	<b>D3589</b>	SHEET 8 OF 8
APPROVED	<i>AK</i>	TITLE	SCALE
DE APPR.	<i>AK</i>	<b>LATCH ASSEMBLY</b>	NTS
DATE	<b>08.06.25</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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